

**AMENDMENTS TO THE SPECIFICATION:**

Please amend the specification as follows:

Please replace paragraph 2 on page 1 of the specification with the following:

In a conventional machine tool, the spindle has a chuck adaptive for chucking thereto one of a variety of rotary tools to be ~~replaceable~~ replaceable with another. For example, the collet chuck falls in a variety of types, such as a draw-bar type configured to draw in or push out a chuck by a draw bar axially movable in the spindle, or a screw-mount type configured with a nut screwed on a distal end of the spindle and configured to be tightened or loosened to thereby tighten or loosen a chuck.

Please replace the paragraph bridging pages 2 and 3 of the specification with the following:

Fig. 1 shows an essential portion of a machine tool including a spindle supporting part 1, such as a spindle holder, on which a spindle 5 is rotatably borne via bearings 3. The spindle 5 has a taper hole 7, in which an axially split cone-frustum-shape chuck member 9, such as a collet chuck, is fit for use to chuck a tool 11, such as an elongate cutting tool. To adjust the chucking to be tight or loose, the chuck member 9 is cooperative with a cap nut 13 (by slidable touching engagement of a bottom face of the former 9, with an annular upside region of a flat bottom part of the latter 13, which is formed with a through hole for removal and application of the tool 11), as the nut 13 is rotatably screwed at its upper part to a male thread 5b formed on a periphery of a distal

end protrusion 5b of the spindle 5, where the taper hole 7 is formed. The machine tool may have ~~to~~two or more spindles.

Please replace the paragraph bridging pages 4 and 5 of the specification with the following:

If the jig 35 is adapted for handling a single tool, the detached or removed tool 11 is carried away together with the jig 35, as the carrier 31 travels to the tool supply station, where the removed tool 11 is returned from the jig 35 to a tool pot. Then, the jig 35 receives a new tool 11, which is carried beneath the chuck member 9, as the carrier 31 travels to the service region for replacement. If the jig 35 is adapted for handling ~~to~~two or more tools, it is simply slid to set the removed tool 11 aside, and concurrently set a new tool 11 beneath the chuck member 9.